

Date: Wednesday, 10/09/2008 1:52:37 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OH-58 STEP ASSY LH
Job Number	: 41927		
Estimate Number	: 12438		
P.O. Number	:	Part Number	: D058677011
This Issue	: 10/09/2008 S.O. No. :	Drawing Number	: D2943 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A <i>01.09.10</i>
First Issue	: 10/09/2008 Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 36562	Material	:
Written By	:	Due Date	: 17/09/2008 Qty: 3 Um: Each
Checked & Approved By	: <i>JUD 08.9.10</i>		
Comment	: Est Rev:B 01.04.11 Combined with D2943-041 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD058-677-011 . CHG 001 *5 09/01/06*

2.0	D2622120C	Step Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 Extrusion D2622-120C
 Batch: *B42155*

3.0	D2734	Step End Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
 D2734 206 Step Endplate
 Batch: *339179*

4.0	D2725	206 Step Lug
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 D2725 206 Step Lug
 Batch: *330882*

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2943-1 from D2622 extrusion as per Dwg D2943

2-Deburr and bevel ends for welding

3-Weld end cap(1) and plate as per Dwg D2943 using Jig DT 8482

SAD 08-12-19 (3)

SAD 08-12-19 (3)

08.12.20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/09/2008 1:52:37 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY LH

Job Number: 41927

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description:

A/R AL ROD

Batch: M109560

M108037

4-Grind end cap welds flush as per dwg D2943

PE 08.12.20

SAD 08-12-22

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PE 08-12-22

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-12-22

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 08-12-23

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 08-12-23

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last end cap(1) as per Dwg D2943 using Jig DT 8482

A/R AL ROD

Batch: M108037

2-Grind end cap welds flush as per dwg D2943

SAD 08-12-23

PE 08.12.23

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PE 08-12-23

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-12-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/09/2008 1:52:38 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY LH

Job Number: 41927

Part Number: D058677011

Job Number:



Seq. #: Machine Or Operation: Description:

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(3X)

Comment: HAND FINISHING RESOURCE #1

1-Pressure wash as per QSI 005

2-Touch up Chemical Conversion Coat as per QSI 005 4.1

M-L 08/12/29

14.0

POWDER COATING

POWDER COATING



M109996



(3X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:30
320°F
10:00

M-L 08/12/29

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(3)

Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2943 and QSI 005 4.4

Batch: M109219

FL 08/12/29

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 09/01/05 (3) LH

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/05 (3) LH

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

19.0

D27311

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Mounting Lug

Batch: 27415

8/10/30

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/09/2008 1:52:38 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY LH

Job Number: 41927

Part Number: D058677011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	D27313	Mounting Lug
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B39441



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
Mounting Lug

SP

21.0	D27315	Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
Mounting Lug
Batch: B15283 B22591

SP

22.0	D27317	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
Mounting Lug
Batch: B41597

SP

23.0	AN411A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)
Bolt
Batch: M106606

SP

24.0	AN412A	Bolt
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)
Bolt

SP

25.0	AN960JD416	Washer
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)
Washer
Batch: M109249

SP

26.0	MS21042L4	Nut
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)
Nut
Batch: M108445

8/12/30

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/09/2008 1:52:38 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY LH

Number: 41927

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 09/01/06 (X3)

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Do58-677-011

Location: _____

PPP Rev: _____

Rev B

9/01/06 (3)

29.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(3)

10/01/07

MF 09-01-00

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

REV. B

SHEET 1 OF 1

SCALE

DATE 05.11.14 TITLE OH-58 STEP ASSEMBLY NTS

A 99.11.19 NEW ISSUE

B 05.11.14 UPDATE FINISHING NOTE

DESIGN RF DRAWN BY RF

CHECKED

APPROVED

DRAWING NO.

RF

RF

D2943

UNDER REVIEW

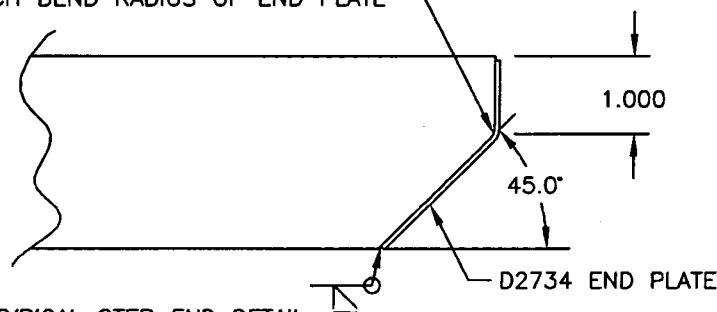
06 DEC 29 2014

RE-DESIGN
SIMILAR TO D206-603

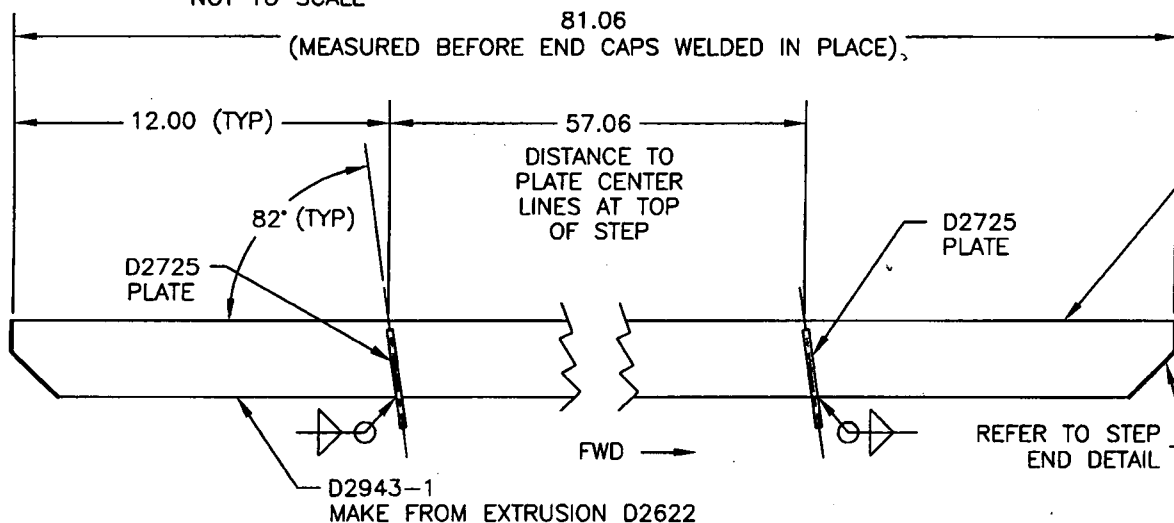
RELEASED
05.11.28-14

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE



APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS

D2943-041 LH STEP ASSEMBLY (SHOWN)
D2943-042 RH STEP ASSEMBLY (OPPOSITE)

D2943-041/-042 OH-58 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2943-041	LH STEP ASSEMBLY
	X	D2943-042	RH STEP ASSEMBLY
1	1	D2622-082*	EXTRUSION
2	2	D2725	PLATE
2	2	D2734	END PLATE

*out per drawing

D2943-041/-042 OH-58 STEP ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 47927

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Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : OH-58 STEP ASSY LH
 Job Number : 41927
 Estimate Number : 12438
 P.O. Number : Part Number : D058677011
 This Issue : 10/09/2008 S.O. No. : Drawing Number : D2943 UNDER REVIEW
 Prsht Rev. : NC Project Number : N/A
 First Issue : 10/09/2008 Type : LARGE FAB ASSY Drawing Revision : B
 Previous Run : 36562 Material :
 Written By : Due Date : 17/09/2008 Qty: 3 Um: Each
 Checked & Approved By : JUD 08.9.10
 Comment : Est Rev:B 01.04.11 Combined with D2943-041 EC

Additional Product

REFERENCE ONLY

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JUD 08.9.16



Comment: Photocopy bluefile & type labels per PPPD058-677-011 CHG 001

2.0 D2622120C Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 Extrusion D2622-120C
 Batch: _____

3.0 D2734 Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
 D2734 206 Step Endplate
 Batch: _____

4.0 D2725 206 Step Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 D2725 206 Step Lug
 Batch: _____

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2943-1 from D2622 extrusion as per Dwg D2943

2-Deburr and bevel ends for welding

3-Weld end cap(1) and plate as per Dwg D2943 using Jig DT 8482